Work Order ID 86083

June-20-12 12:57:05 PM

86083

Item ID: D4464-041

Revision ID:

Item Name: Fuel Tank Assembly

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 20/06/2012 **Start Qty:** 1.00 *1*

Required Date: 04/07/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** MLJ **Date:** 12/06/20 **Tooling:** **Date:**

Run Start *NR1*

QC: **Date:** **SPC (Y/N):** **Date:**

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4464	**Revision Nbr** D								
100 *100* Large Fab	Weld per dwg A/R Aluminum rod Batch: 120854 122130	0.00				1	Ø		12.07.11
Large Fab	Memo	0.00							

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4463-7 fwd end

PURGE INSIDE OF TANK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: _________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86083

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86083

Item ID: D4464-041

Revision ID:

Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Start Qty:** 1.00 *1*

Required Date: 04/07/2012 **Req'd Qty:** 1.00 *1*

Reference:

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00				1	Ø		BE 12/07/11
	Memo	0.00							
120 *120* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 120854	0.00				1	Ø		[signature] 12.07.18
	Memo 1-Weld top D4463-1 using DT9811 and DT9810 ***PURGE INSIDE OF TANK***	0.00							
123 *123* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo ***Pressure Test as per dwg D4464***	0.00							

(DAS 16 9-59) 7/..../..

PTO

Passes water + [illegible] Power test.

Dart Aerospace Ltd

W/O: 86083		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4464-041 **PAR #:** ______ **Fault Category:** Large Fab welding **NCR:** Yes No **DQA:** [signature] **Date:** 12/08/14

Resolution: ______ **Disposition:** Rework **QA: N/C Closed:** [initials] **Date:** 12/08/14

NCR: 12-1688		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
12/07/24	# 20	Found at inspection multiple leaks on the base of the tank when performing the water & talcum powder test. R.C. Process.	DAS 22 12.07.24	touch up locations marked from QC inspections as per QS1 005 a/n 120854	[signature] 12.07.25	DAS 16 12/07/25	DAS 22 12.07.24	DAS 16 12/07/24

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 86083

June-20-12 12:57:05 PM

86083

Item ID: D4464-041

Revision ID:

Item Name: Fuel Tank Assembly

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 20/06/2012 **Start Qty:** 1.00 *1*

Required Date: 04/07/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00				1	Ø	12/07/25	DAS 18
	Memo	0.00							
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				1X	Ø		M 12/07/26
	Memo 1- brush alodine on tank. No alodine inside	0.00							
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat	0.00				1	Ø		BR 12-7-26
	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86083
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86083

Item ID: D4464-041
Revision ID:
Item Name: Fuel Tank Assembly
Start Date: 20/06/2012 **Start Qty:** 1.00 *1*
Required Date: 04/07/2012 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Powdercoat Powder Coating		0.00				1 X	Ø		12/07/26
	Memo ***Mask prior to powdercoat*** POWDER COAT ANSI 61 GREY AS PER DWG AND QSI 005 4.3 Start Time: 9:30 Oven Temperature: 320 °F Finish Time: 10:00	0.00							
180 *180* QC Quality Control	QC3- Inspect Part Finish	0.00				1	Ø		12-7-26
	Memo	0.00							

M118535

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86083
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86083

Item ID: D4464-041
Revision ID:
Item Name: Fuel Tank Assembly

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 20/06/2012 **Start Qty:** 1.00 *1*
Required Date: 04/07/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Small Fab		0.00				1X			02/08/08
Small Fab	**Memo** 1- Mask off area, where access cover is applied 2- Abrade surface with red scotch brite 3- Wipe with clean cloth and wash and wipe 4- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890 A/R proseal 890 Batch: M122441	0.00							
200 *200* QC	QC5- Inspect part completeness to step on W/O	0.00	DAS 16 12/08/10						
Quality Control	**Memo**	0.00							

tested with water and air pressure @ 4.5psi. 12-08-08

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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11

Work Order ID: 86083

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5 Placard		Manufactured	No			190	Each	8.0000	2 **	2 ✓	JB		
D3997-11 Placard		Manufactured	No			190	Each	11.0000	1 **	1 ✓	JB		
D3997-17 Placard		Manufactured	No			190	Each	13.0000	1 **	1 ✓	JB	12/07/25	

D3997-5 locations:

Location	Loc Qty	Loc Code
ST141	98	
72611	82	
81028	8	
83650	8	

81028

D3997-11 locations:

Location	Loc Qty	Loc Code
ST141	11	
82957	11	

82957

D3997-17 locations:

Location	Loc Qty	Loc Code
ST141	13	
80309	3	
82958	10	

80309

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86083

86083

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

D3997-29 Manufactured No 190 Each 14.0000 1 1 ✓

D3997-29 **

Placard JB

Location	Loc Qty	Loc Code
ST141	14	
80845	14	80845

D3997-43 Manufactured No 190 Each 11.0000 1 1 ✓

D3997-43 ** 80310 JB 12/07/25

Placard

Location	Loc Qty	Loc Code
ST141	11	
82960	11	

D3999-7 Manufactured No 100 Each 5.0000 1 1

D3999-7 ** 12-07-11

Corner

Location	Loc Qty	Loc Code
WA014	5	
~~71695~~	1	
75156	4	1

D3999-9 Manufactured No 100 Each 4.0000 1 1

D3999-9 ** 12-07-10

Angle

Location	Loc Qty	Loc Code
WA014	4	
~~71696~~	1	
82545	3	1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86083

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083
D4464-041

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

D3999-11
D3999-11
Earth Tab

Manufactured	No	100	Each	18.0000	1	1	**	12.07.10

Location	Loc Qty	Loc Code
WA	25	
84161	17	
WA013	-8	
WA014	1	
~~75180~~	1	

D4000-1
D4000-1
Fuel Supply Fitting

Manufactured	No	100	Each	9.0000	1	1	**	12.07.11

Location	Loc Qty	Loc Code
WA	9	
~~80029~~	1	
83811	8	

D4000-5
D4000-5
Fuel Tank Vent Fitting

Manufactured	No	100	Each	7.0000	1	1	**	12.07.11

Location	Loc Qty	Loc Code
WA013	7	
~~80030~~	1	
83813	6	

D4000-9
D4000-9
Grommet

Manufactured	No	100	Each	2.0000	3	3	**	12.07.16

Location	Loc Qty	Loc Code	
WA014 B85907	2		3
~~83814~~	2		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

June-20-12 12:57:09 PM

Work Order ID: 86083 *86083*

Parent Item: D4464-041 *D4464-041*

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

Item	Type						
D4000-045 *D4000-045* Fuel Pickup Fitting Assemby	Manufactured	No	100	Each	3.0000	1 **	1

Location		Loc Qty	Loc Code	
WA	B87919	1		1
	~~81071~~	1		
WA013		1		
	~~72078~~	1		
WA014		1		
	~~71669~~	1		

12.07.23

Item	Type						
D4008-11 *D4008-11* Hinge Half	Manufactured	No	100	Each	8.0000	1 **	1

Location		Loc Qty	Loc Code	
WA		8		
	~~80037~~	2		
	80838	6		1

12.07.10

Item	Type						
D4008-041 *D4008-041* Fuel Filler Splash Guard Assembly	Manufactured	No	190	Each	3.0000	1 **	1 ✓

Location		Loc Qty	Loc Code	
ST108		3		
	84013	3		84013

JB 12/07/25

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

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Work Order ID: 86083 — *86083*

Parent Item: D4464-041 — *D4464-041*

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

D4023-3
D4023-3
Cap and Flange

Manufactured	No	190	Each	16.0000	1	1	**

Signed: 12.07.10

Location	Loc Qty	Loc Code	
ST084	15		
81898	5		1
84422	10		
ST110	1		
~~73514~~	1		

D4025-5
D4025-5
Fuel Quantity Sender

Manufactured	No	190	Each	9.0000	1	1	**

JB 12/07/25

Location	Loc Qty	Loc Code	
ST141a	4		
76894	1		
81899	3		81899
ST143	5		
84421	5		

D4057-1
D4057-1
Retaining Ring

Manufactured	No	100	Each	24.0000	3	3	**

Signed: 12.07.16

Location	Loc Qty	Loc Code	
WA013	24		
~~71166~~	2		
83656	22		3

D4062-041
D4062-041
Tank Support Assembly

Manufactured	No	190	Each	2.0000	1	1	**

Signed: 12.07.18

Location	Loc Qty	Loc Code	
WA	2		
85235	2		1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

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Work Order ID: 86083 *86083*

Parent Item: D4464-041 *D4464-041*

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

D4124-1
D4124-1
Tab

Manufactured No 100 Each 21.0000 4 4 **

Location		Loc Qty	Loc Code
WA		21	
	~~76895~~	7	
	83824	14	

D4125-1
D4125-1
Sump

Manufactured No 100 Each 3.0000 1 1 **

Location		Loc Qty	Loc Code
WA		3	
	~~81151~~	1	
	83825	2	

D4125-3
D4125-3
End

Manufactured No 100 Each 3.0000 1 1 **

Location		Loc Qty	Loc Code
WA		3	
	~~81152~~	1	
	83826	2	

D4404-3
D4404-3
Cushion, Side

Manufactured No 100 Each 1.0000 1 1 **

Location		Loc Qty	Loc Code
ST242A		1	
	76898	1	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ____________________ QA: N/C Closed: _________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-20-12 12:57:10 PM

Work Order ID: 86083 *86083*

Parent Item: D4464-041 *D4464-041*

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

D4404-5 *D4404-5* Cushion, Fwd — Manufactured — No — 100 — Each — 22.0000 — 4 — 4 ✓ ** JB 12/07/25

Location	Loc Qty	Loc Code
ST242A	22	
76899	1	
85596	21	85596

D4462-1 *D4462-1* Baffle — Manufactured — No — 100 — Each — 6.0000 — 1 — 1 ** 12.07.11

Location	Loc Qty	Loc Code
WA	6	
83827	2	1
84353	4	

D4462-3 *D4462-3* Baffle — Manufactured — No — 100 — Each — 4.0000 — 1 — 1 ** 12.07.11

Location	Loc Qty	Loc Code
WA	4	
84355	4	1

D4463-041 *D4463-041* Tank Top Assembly — Manufactured — No — 120 — Each — 2.0000 — 1 — 1 ** 12.07.11

Location	Loc Qty	Loc Code
WA	2	
84826	2	1

D4463-3 *D4463-3* Tank Aft End — Manufactured — No — 100 — Each — 0.0000 — 1 — 1 ** 12.07.11

B84354 = (1)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86083

86083

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

Item	Type								
D4463-5 *D4463-5* Tank Upper Cut Out	Manufactured	No	100	Each	8.0000	**	1	1	12.07.11

Location	Loc Qty	Loc Code
WA	8	
83834	8	

Item	Type								
D4463-7 *D4463-7* Tank Fwd End	Manufactured	No	100	Each	0.0000	**	1	1	12.07.11

B84357 = (1)

Item	Type								
D4463-9 *D4463-9* Tank Back	Manufactured	No	100	Each	4.0000	**	1	1	12.07.11

Location	Loc Qty	Loc Code
WA	4	
84358	4	

Item	Type								
D4463-11 *D4463-11* Tank Front	Manufactured	No	100	Each	2.0000	**	1	1	12.07.10

Location	Loc Qty	Loc Code
WA	2	
84766	2	

Item	Type								
D4463-13 *D4463-13* Tank Bottom	Manufactured	No	190	Each	3.0000	**	1	1	12.07.10

Location	Loc Qty	Loc Code
WA B86575	3	
~~82237~~	2	
~~83831~~	1	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-20-12 12:57:10 PM

Work Order ID: 86083

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083
D4464-041

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

AN3H5A Purchased No 190 Each 27.0000 5 5 ✓

AN3H5A

Bolt

** JB

Location	Loc Qty	Loc Code	
ST351	27		
118112	1		
120693	26		120693

MS21042L3 Purchased No 190 Each 1,654.000 4 4 ✓

MS21042L3

Nut

** JB

Location	Loc Qty	Loc Code	
ST300	1654		
117885	32		
119017	816		
119075	138		
121444	668		121444

MS35206-266 Purchased No 190 Each 92.0000 4 4

MS35206-266

Screw

** JB 12/07/25

Location	Loc Qty	Loc Code	
ST294	92		
119850	92		119850

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ___________________ QA: N/C Closed: _________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

June-20-12 12:57:10 PM

Work Order ID: 86083

86083

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

NAS1149D0363J Purchased No 190 Each 1,425.000 37 37 ✓

NAS1149D0363J **

Washer

JB

Location	Loc Qty	Loc Code	
ST298	1425		
116025	2		
117601	61		
118612	3		
119537	33		
120142	13		
120308	17		
121243	342		
121524	954		121524

AN3-4A Purchased No 190 Each 559.0000 24 24 ✓

AN3-4A **

Bolt

JB

Location	Loc Qty	Loc Code	
ST350	559		
102832	88		
104291	4		
104625	81		104625
107321	8		
117317	98		
120308	80		
120770	200		

D4577-1 Manufactured No 190 Each 3.0000 1 1 ✓

D4577-1 **

Rear Access Panel

JB 12/07/25

Location	Loc Qty	Loc Code	
ST237A	3		
84365	3		84365

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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Picklist Print

June-20-12 12:57:10 PM

Work Order ID: 86083 *86083*

Parent Item: D4464-041 *D4464-041*

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 **Required Date:** 04/07/2012

Start Qty: 1.00 **Required Qty:** 1.00

D4577-3 Manufactured No 190 Each 3.0000 1 1 ✓

D4577-3

Middle Access Panel

** JB

Location	Loc Qty	Loc Code
ST237A	3	
85719	3	85719

D4577-041 Manufactured No 190 Each 3.0000 1 1

D4577-041

Fwd Access Panel Assembly

** JB 12/07/25

Location	Loc Qty	Loc Code
ST237A	3	
84368	3	84368

NAS1149D0332J QTY: 5x B# M121708 12/08/08

12.08.08

AN3-6A QTY: 4x B# M120644 12/08/08

12.08.08

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4464-041	FUEL TANK ASSEMBLY
2	2	D3997-5	PLACARD "AUX FUEL DRAIN"
3	1	D3997-11	PLACARD "LOADING"
4	1	D3997-17	PLACARD "STOWAGE"
5	1	D3997-29	PLACARD "WARNING"
6	1	D3997-43	PLACARD "EARTH"
7	1	D3999-7	CORNER
8	1	D3999-9	ANGLE
9	1	D3999-11	EARTH TAB
10	1	D4000-1	FUEL SUPPLY FITTING
11	1	D4000-5	FUEL TANK VENT FITTING
12	3	D4000-9	GROMMET
13	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
14	1	D4008-11	TANK HINGE HALF
15	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
16	1	D4023-3	FUEL CAP
17	1	D4025-5	FUEL SENDER
18	3	D4057-1	RETAINING RING
19	1	D4062-041	TANK SUPPORT ASSEMBLY
20	4	D4124-1	TAB
21	1	D4125-1	FWD SEDIMENT BOWL
22	1	D4125-3	AFT SEDIMENT BOWL
23	1	D4404-3	CUSHION, SIDE
24	4	D4404-5	CUSHION, FWD
25	1	D4462-1	BAFFLE
26	1	D4462-3	BAFFLE
27	1	D4463-041	TOP TANK ASSEMBLY
28	1	D4463-3	TANK AFT END
29	1	D4463-5	TANK UPPER CUT OUT
30	1	D4463-7	TANK FORWARD END
31	1	D4463-9	TANK BACK
32	1	D4463-11	TANK FRONT
33	1	D4463-13	TANK BOTTOM
34	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
35	1	D4577-1	REAR ACCESS PANEL
36	1	D4577-3	MIDDLE ACCESS PANEL
37	24	AN3-4A	BOLT
38	5	AN3H5A	BOLT
39	4	MS21042L3	NUT
40	4	MS35207-266	SCREW
41	37	NAS1149D0363J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. E6083 MCJ
12/06/20

RELEASED
2012-05-09

REV.	DESCRIPTION	BY	DATE
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	12.05.02

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4464 — REV. D — SHEET 1 OF 5

TITLE: TANK ASSEMBLY — SCALE: NTS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

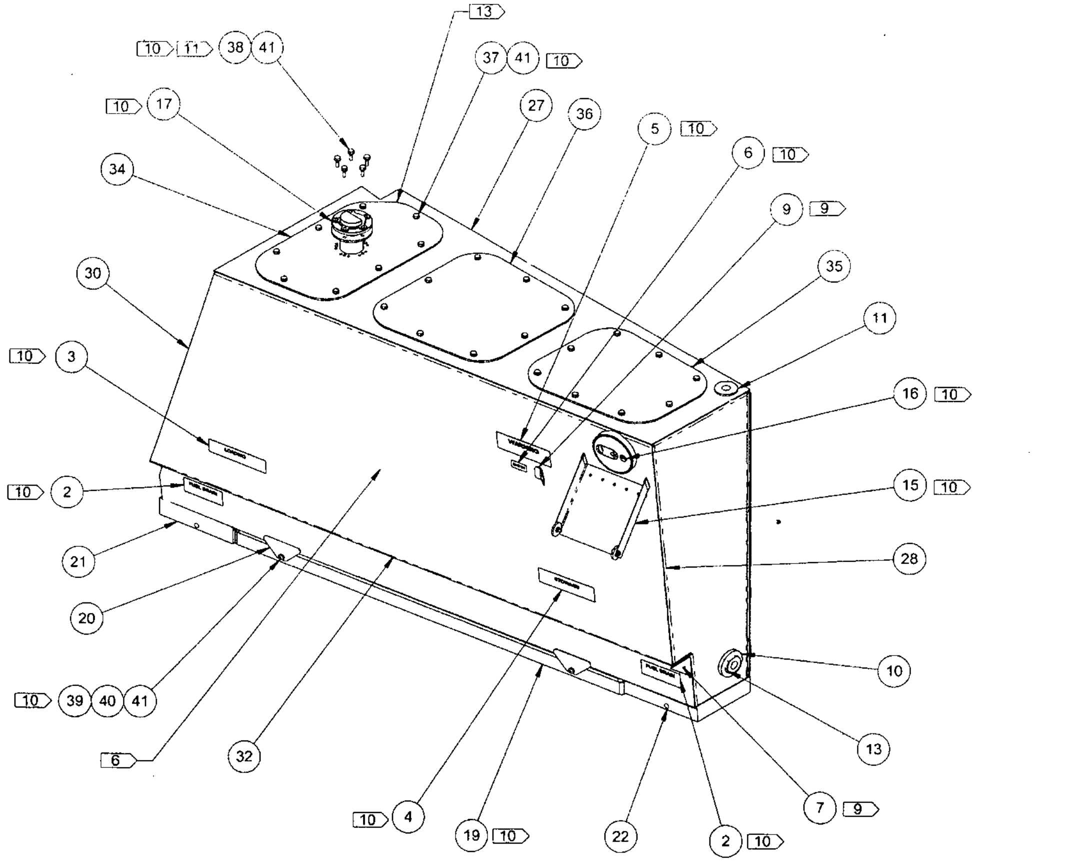
Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

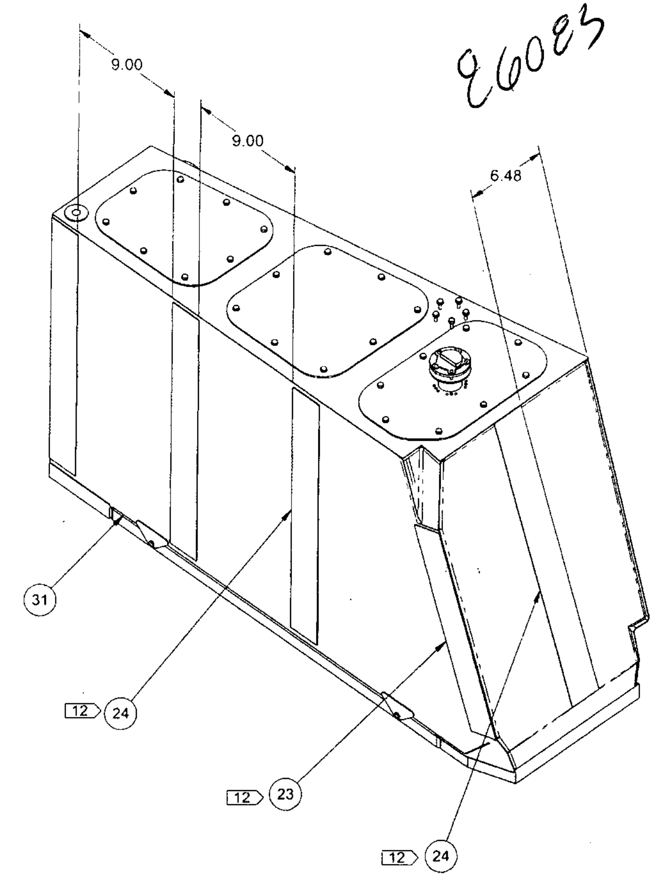
Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

E6083





D4464-041 FUEL TANK ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
7) WEIGHT: 35.81 lbs
8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 4.3. VERIFY NO LEAKS
9) MASK PRIOR TO POWDER COAT
10) INSTALL AFTER POWDER COAT
11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
12) INSTALL CUSHIONS AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
13) INSTALL D4577-041/-3/-5 ACCESS PANELS WET WITH PROSEAL 890.

RELEASED 2012-05-09

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4464 — REV. D — SHEET 2 OF 5
MFG. APPR.		
APPROVED		TITLE: TANK ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	12.05.02	

Dart Aerospace Ltd

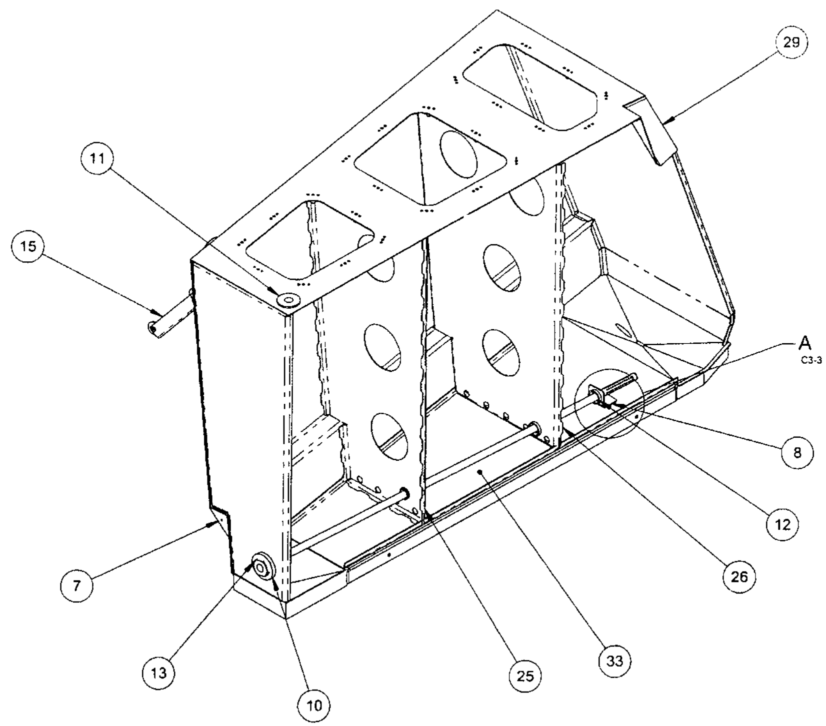
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

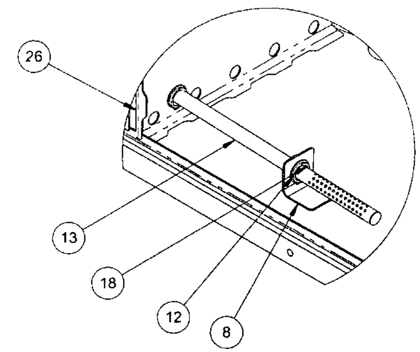
Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X
B6-3

RELEASED 2012-05-09

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D4464 REV. D SHEET 3 OF 5
CHECKED		
MFG. APPR.		
APPROVED		TITLE TANK ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.05.02	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

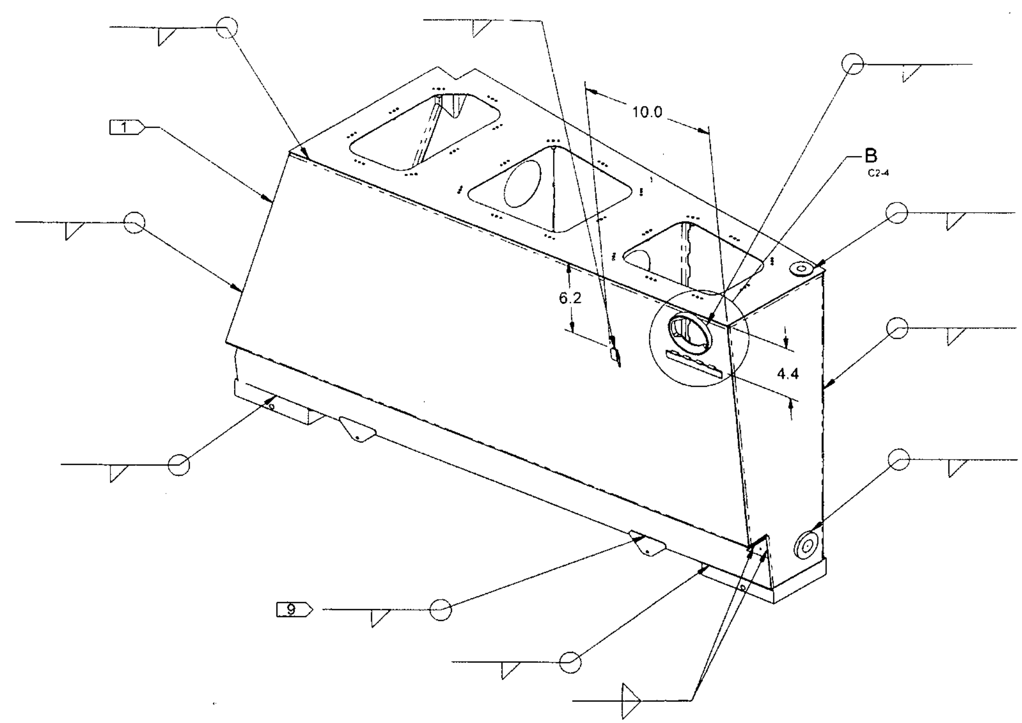
Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

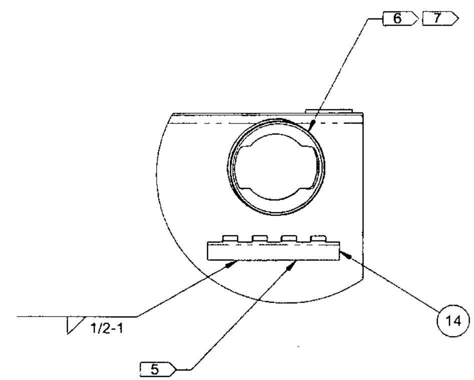
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DETAIL B
ROTATED FOR CLARITY
SCALE 2X
C2-4

RELEASED 2012-05-09

D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

NOTES:
1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - ALL SWARF REMOVED
3) ACCEPTABLE TO DRILL 6 (TYP) Ø0.312 HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
4) ACCEPTABLE TO DRILL 7 (TYP) Ø0.312 HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
5) CENTER HINGE BELOW FUEL CAP FLANGE
6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
8) WELD PER DART QSI 004
9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING; D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING. (D)

DESIGN	[signature]	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	[signature]	
CHECKED	[signature]	DRAWING NO. D4464 — REV. D — SHEET 4 OF 5
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE: TANK ASSEMBLY — SCALE: NTS
DE APPR.	[signature]	
DATE	12.05.02	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

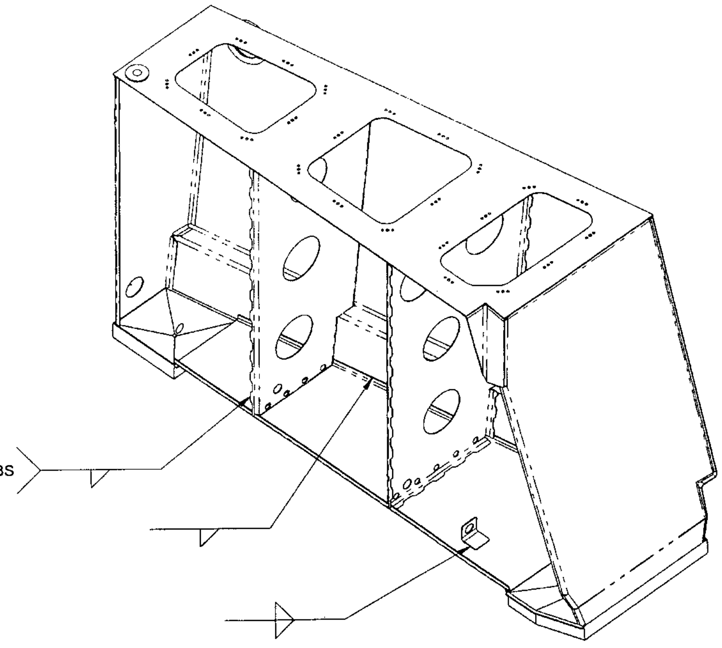
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

E6083



RELEASED 2012-05-09

D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4464	REV. D SHEET 5 OF 5
MFG. APPR.			
APPROVED		TITLE TANK ASSEMBLY	SCALE NTS
DE APPR.			
DATE	12.05.02		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ______

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ______

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